

Product Data Sheet



EPDM BONDING ADHESIVE

Item Description	Item Number
5 Gallon (18.9 L)	W590010152

Description

GenFlex EPDM Bonding Adhesive is a solvent based contact adhesive designed specifically for bonding GenFlex EPDM membranes and flashings to GenFlex GL ISO, HD ISO, CG (Coated Glass Facer) ISO insulations, wood, metal, masonry, and other acceptable substrates.

Method of Application

1. Surfaces to receive GenFlex EPDM Bonding Adhesive shall be clean, smooth, dry, free of sharp edges, loose and foreign materials, oil, grease, and other contaminants. Sweep the mating surface of the membrane with a stiff broom to remove excess dusting agent, if present, or other contaminants from the mating surface.
2. Stir the adhesive thoroughly before and during use, achieving a uniform mix with no sediment on the bottom and no marbling evident.
3. Apply adhesive at about the same time to both the exposed underside of the sheet and the substrate to allow approximately the same flash-off time.
4. GenFlex EPDM Bonding Adhesive may be applied with a solvent-resistant paint roller or mechanical equipment designed to apply flammable solvent-based adhesives.
5. Apply by rolling the adhesive on both mating surfaces. GenFlex EPDM Bonding Adhesive should be applied evenly to avoid globs or puddles.
6. As an option, spray GenFlex EPDM Bonding Adhesive and back-roll the adhesive uniformly and evenly with a solvent-resistant paint roller. **Care must be taken not to apply adhesive over any area that will later be cleaned and spliced to another sheet or flashing.**
7. Allow GenFlex EPDM Bonding Adhesive to flash off until tacky. Touch the adhesive surface with a clean, dry finger to be certain that the adhesive is dry and does not stick or string. While pushing straight down to check for stringing, also push forward on the adhesive at an angle to ensure that the adhesive is ready (flushed off) throughout its thickness. If either motion exposes wet or stringy adhesive when the finger is lifted, then it is not ready for mating. Flash-off time will vary depending on ambient air conditions.
8. Starting at the fold, roll the previously coated portion of the sheet into the coated substrate slowly and evenly to maintain position and minimize wrinkles.
9. To ensure proper contact, compress the bonded half of the sheet to the substrate with a stiff push broom using heavy pressure.

Storage

- Store in original unopened containers at temperatures between 60 °F (16 °C) and 80 °F (27 °C) until ready for use.
- For optimum results, rotate stock to ensure stored material has not exceeded the shelf life of one year.

Shelf Life

- Shelf life of 24 months can be expected if stored in original sealed container at temperatures between 60 °F (16 °C) and 80 °F (27 °C). If exposed to lower temperatures, restore to room temperature prior to use.
- Shelf life will be shortened if exposed to elevated temperatures.

Precautions

- Flammable. Keep away from fire and open flame and other possible ignition sources during storage and use. Do not smoke when using.
- Harmful or fatal if swallowed.
- Avoid prolonged inhalation.
- Avoid prolonged contact with skin. Gloves should be worn (OSHA approved).
- Avoid eye contact by wearing safety glasses with side shields or safety goggles.
- **For professional use only**
- Keep out of reach of children.
- Thinning is not allowed.
- Do not use for splicing.
- Do not use with TPO or TPO fleece backed membranes.
- Use only in well ventilated areas.
- Cover tightly when not in use.
- Review Safety Data Sheet specified on the Bonding Adhesive container label.
- Recommended cleaner is GenFlex Cleaner.

LEED® Information

Post-Consumer Recycled Content: 0%
 Post Industrial Recycled Content: 0%
 Manufacturing Location: South Bend, IN



NOTE: LEED® is a registered trademark of the U.S. Green Building Council

Typical Properties	
Property	Typical Value
Color	Yellow
Base	A blend of polychloroprene and SBR rubbers
Solvents	A blend of Acetone, Toluene, Hexane and Xylene
Solids	≥ 23%
Viscosity	3,300-3,800 cps, R.V.F. #3 spindle @ 10 RPM
Specific Gravity	0.803-0.877
V.O.C. Content	5.282 lb/gal (633 g/L)

Packaging Data

Property	Value
Pail	5 gallon (18.9 L)
Weight	41 lb (18.6 kg)
Coverage	A coverage rate of 45 - 60 ft ² /gal (1.10 – 1.47 m ² /L) may be obtained depending on the substrate. Some insulation surfaces are more uneven and porous and will result in a lower coverage rate while smooth non-porous substrates will result in higher coverage rates. Rates are based on roller application to both mating surfaces. Very porous substrates (rough wood, concrete block) may require <u>two</u> coats of EPDM Bonding Adhesive BA-2004(T), to ensure proper adhesion. This can be determined by adhering a small piece of membrane to the porous substrate to verify the bonding strength. Some insulation surfaces are more uneven and porous and will result in a lower coverage rate while smooth non-porous substrates will result in higher coverage rates. Rates are based on roller application to both mating surfaces.
Units per Pallet	45 – 5-gallon pails

Approved Power Application Equipment:

Garlock 25ST Roller Boss Power Roller

4 hp Honda Engine, 4 CFM Compressor, 25-gal pressurized supply tank (20 gal for material; 60-80 psi), up to 100 psi rating, 2 – ¾" x 30' supply hoses with swivels, 2 – 18" roller head assemblies

Garlock 2120 Commander Sprayer

18 hp Kohler Engine, 4500 psi Rating, 5 gallon per minute flow, 1200 psi pressure (minimum), Pump Displacement 45:1, GPM Rating: up to 5 GPM, ½" x 100' hose, 2" Intake pipe with screen, 5 or 55-gal drum containers, Graco Spray Tips: .023 to .031 diameter hose

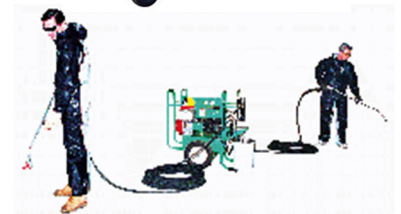
Garlock Twin Gun Airless Sprayer

6.5 hp Honda Engine, 3000 psi Rating, Pump Displacement 30:1, GPM Rating: up to 1 gpm, up to 400' of single ½" diameter hose, Up to 200' of dual ½" diameter hose, ¾" Intake pipe with screen, 5 or 55 gal drum containers, Bulk tank containers, Graco Spray Tip: .019 to .025 diameter hose (1850 psi operating pressure)

Graco Spray Equipment:

P70EC4-70 – 70:1 Xtreme Sprayer Package w/Heavy Duty car, Hopper package, w/NXT motor and Data Track, Xtreme-Duty high pressure hose, ¾" x 50', 7250 psi, with ¼" x 6' whip hose, XTR-7 applicator with XHD821-825 tip.

Please contact Amrize Technical Services at 800-428-4511 for further information.



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